

Date: Tuesday, 21/10/2008 2:45:56 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARSHOE
<b>Job Number</b> : 42776	
<b>Estimate Number</b> : 10614	
<b>P.O. Number</b> :	<b>Part Number</b> : D265621
<b>This Issue</b> : 21/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2656 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 38748	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 04/11/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JD 08-10-21</u>	
<b>Comment</b> : Est: D 02.10.25 Re-format KJ Est Rev:E Now on Waterjet 06-11-02 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M1010S20GA	1010/1025 SHEET
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**Comment:** Qty.: 0.9371 sf(s)/Unit Total : 9.3713 sf(s)  
 1018 20 ga .040" thk  
 Batch: 109289 IB 8-11-6

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D2656  
 Dwg Rev: D IB 8-11-6  
 Prog Rev: D

2-Deburr if necessary IB 8-11-6



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

508/11/11 (13)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 Form bend & joggle as per Dwg D2656 using DT8261 & DT8326

508/11/11 (13)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 21/10/2008 2:45:56 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 42776

Part Number: D265621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/11/12 (13)

7.0

POWDER COATING

POWDER COATING



M 10 6 442



(13X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15  
320 OF  
10:45

M-1 08/11/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MD



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-13

(X13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(13X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F P - 20

M-1 08/11/13

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 4277p
<b>Description:</b> Wearshoe		<b>Part Number:</b> D2656-21
<b>Inspection Dwg:</b> D2656	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.700	+/-0.010	32.700	x			
27.250	+/-0.010	27.250	x			
21.800	+/-0.010	21.800	x			
16.350	+/-0.010	16.350	x			
10.900	+/-0.010	10.902	x			
5.450	+/-0.010	5.449	x			
2.000	+/-0.010	2.000	x			
2.000	+/-0.010	2.000	x			
1.885	+/-0.010	1.887	x			
0.300	+/-0.010	0.303	x			
0.300	+/-0.010	0.304	x			

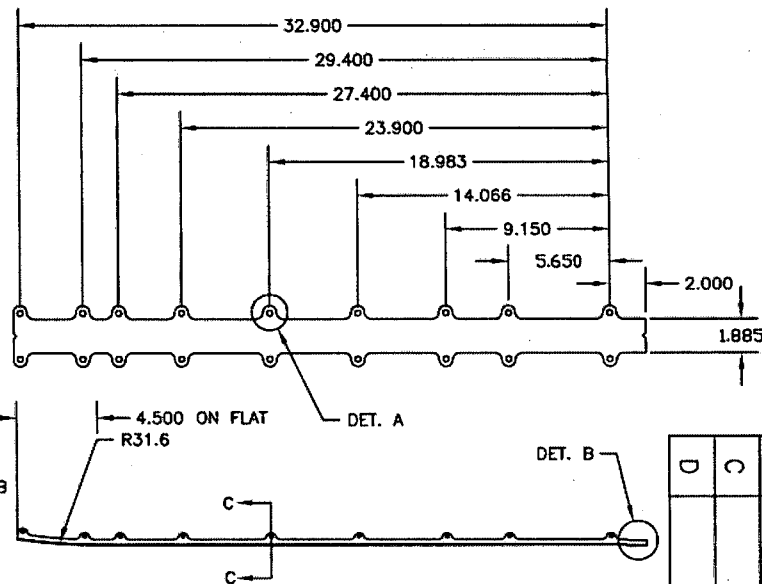
<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-11-6	<b>Date:</b> 02/11/10	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	

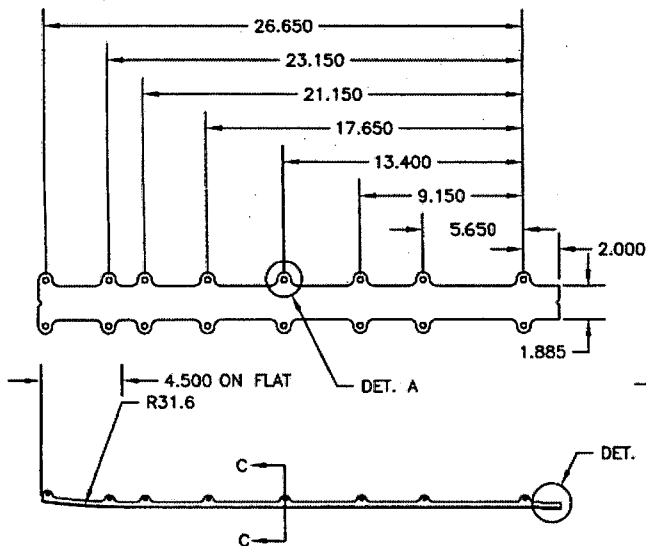


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DS	CP	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. D	
		D2656	SHEET 1 OF 4	
DATE	TITLE	SCALE		
05.08.17	WEARSHOE	1:10		
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

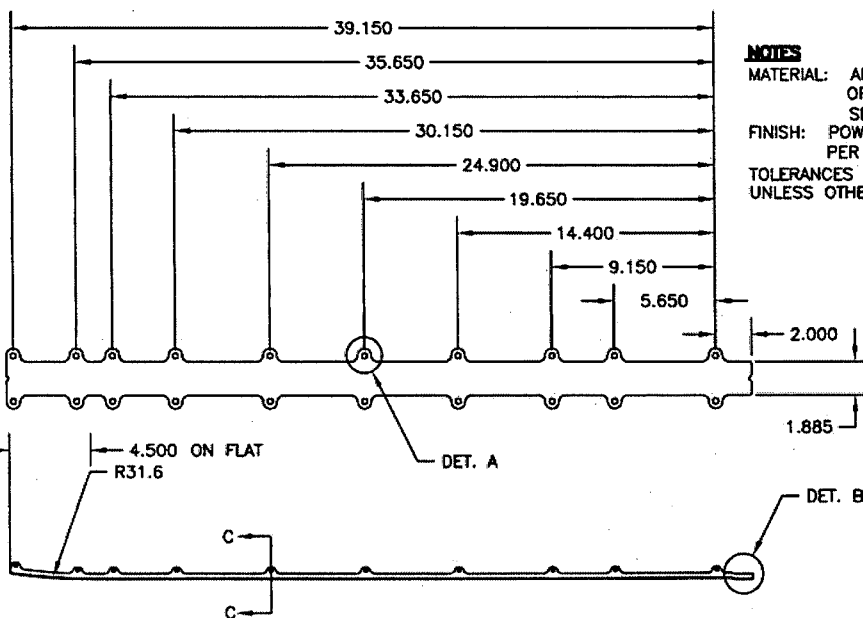
D2656-13



D2656-11



D2656-15



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

RELEASED  
05-09-06

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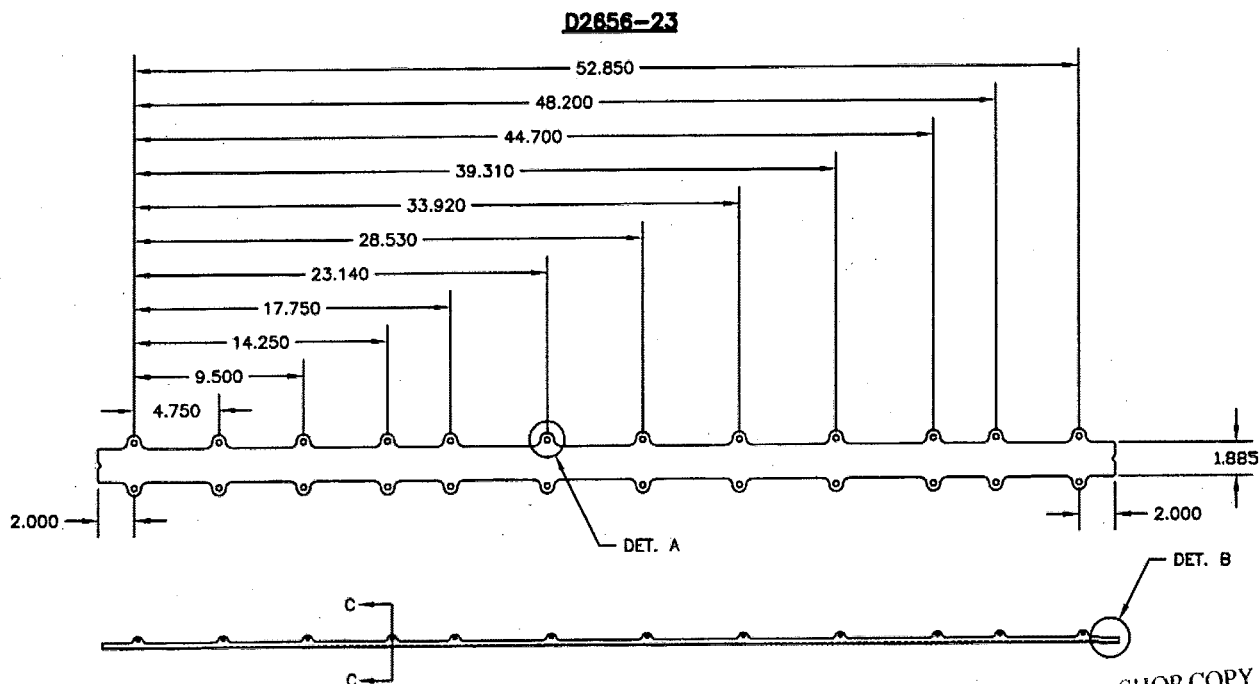
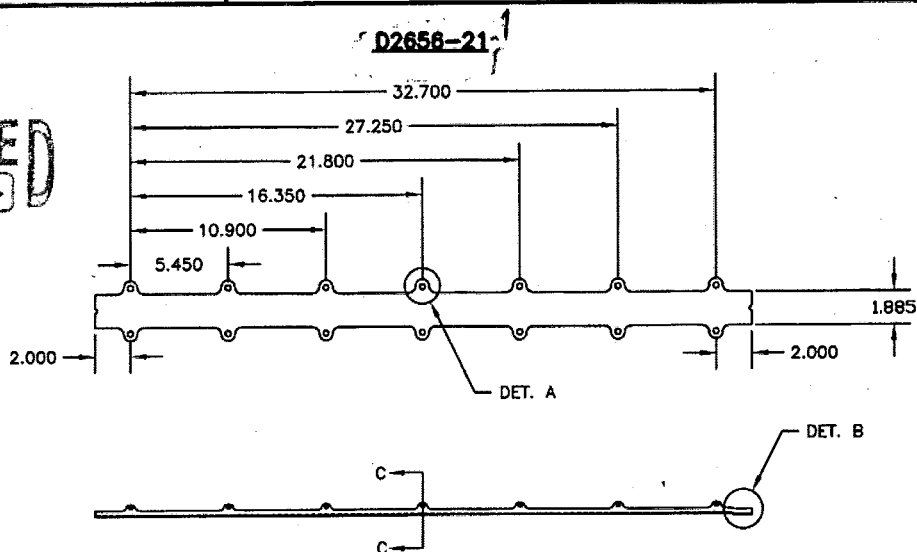
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

RELEASED  
05.07.06



**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
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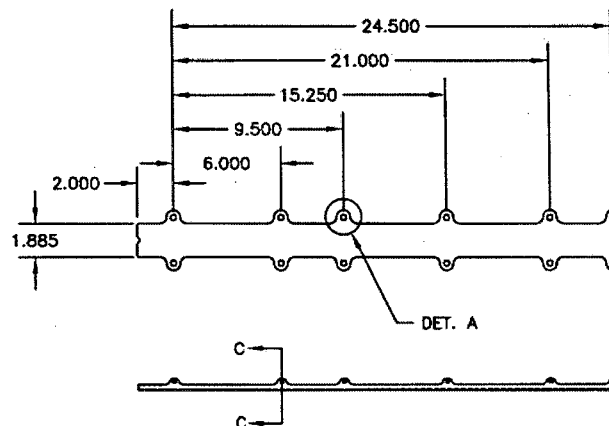
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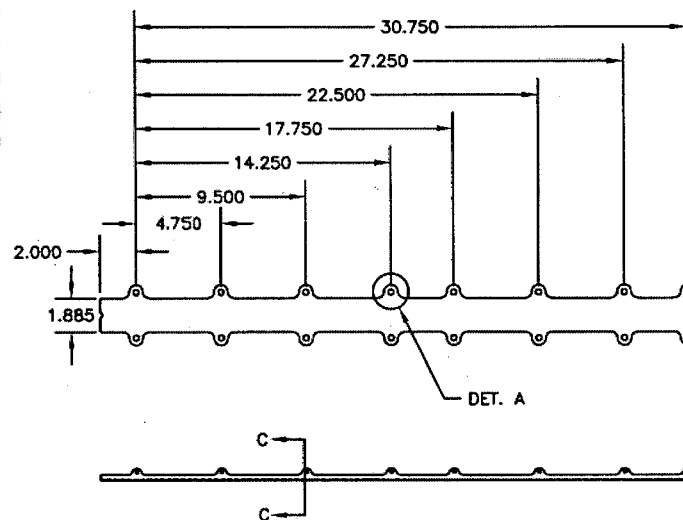


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DATE	05.08.17	DRAWING NO.	D2656	REV. D
		TITLE	WEARSHOE	SHEET 3 OF 4
				SCALE
				1:10

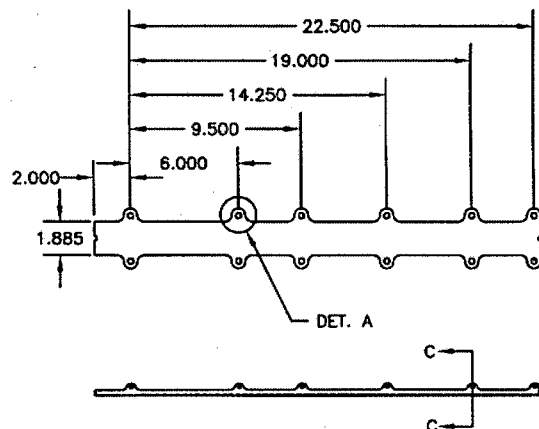
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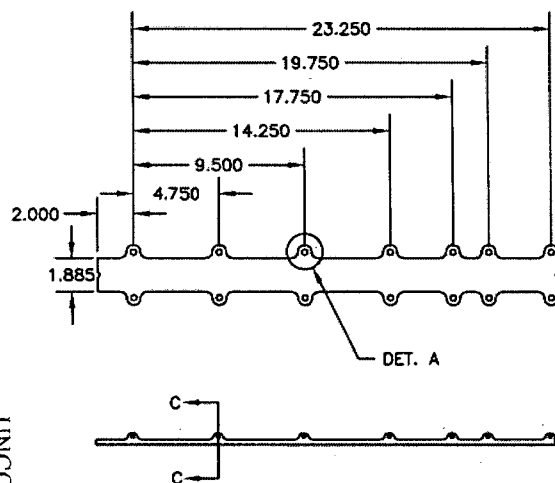
D2656-37



D2656-31



D2656-35



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05.07.06

NOTES

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SERIES STEEL, 20 GAUGE (0.040 THICK)  
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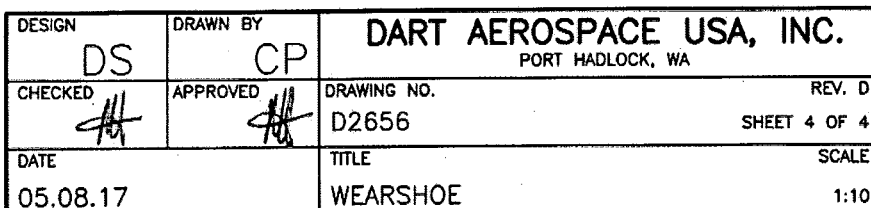
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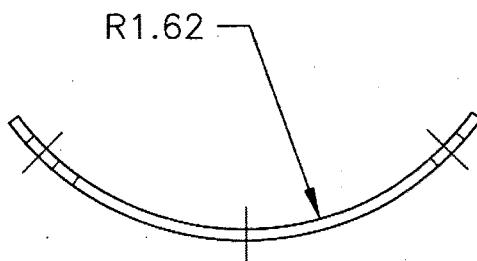
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NO. 20724





## R1.62



RELEASE  
05.09.06

Technical drawing of a mechanical part showing a cross-section. The drawing includes the following dimensions and features:

- R0.110**: Radius of the inner semi-circular feature.
- 0.300**: Width of the central vertical slot.
- R0.375**: Radius of the outer semi-circular feature.
- 0.185**: Thickness of the part.

15°

1.000

0.040 JOGGLE

LONG JOGGLE

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